

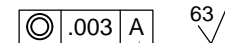
 <b>RED BARN MACHINE</b>			
<b>TITLE</b> RBST1021 THRU 1040 DP SERIES SWAGING TOOL; SECONDARY SEAT			
<b>DWG NO.</b> TOOL# (see chart)-13			<b>REV</b> 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± 5° X ± .1		<b>DRAWN BY:</b> PERRITT <b>APPROVED</b> HEAT TREAT FINISH SPEC <b>BLACK OXIDE</b> USED ON BEARING <b>SEE Pg. 1</b>	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
<b>SCALE</b> NTS	<b>DATE</b> 4-26-08	<b>SHEET</b> 8	of 9

 <b>RED BARN MACHINE</b>			
<b>TITLE</b> RBST1021 THRU 1040 DP SERIES SWAGING TOOL; PRIMARY SEAT			
<b>DWG NO.</b> TOOL# (see chart)-11			<b>REV</b> 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1  FRACTIONS ± 1/32 ANGLES ± 5°		<b>DRAWN BY:</b> PERRITT <b>APPROVED</b>  <b>HEAT TREAT</b> <b>FINISH</b> BLACK OXIDE <b>SPEC</b>  USED ON BEARING  <b>SEE Pg. 1</b>	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
<b>SCALE</b> NTS	<b>DATE</b> 4-26-08	<b>SHEET</b> 7	of 9




 <b>RED BARN MACHINE</b>	
<b>TITLE</b> RBST1021 THRU 1040 DP SERIES SWAGING TOOL; PIN	
<b>DWG NO.</b>	<b>REV</b> 2
<b>TOOL#</b> (see chart)-9	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> PERRITT <b>APPROVED</b> HEAT TREAT FINISH SPEC <b>BLACK OXIDE</b> USED ON BEARING <b>SEE Pg. 1</b>
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
<b>SCALE</b> NTS	<b>DATE</b> 4-26-98 <b>SHEET</b> 6 of 9

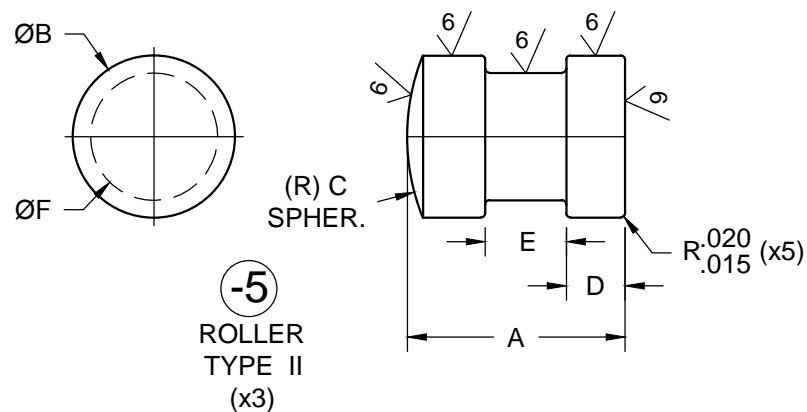



## GUIDE

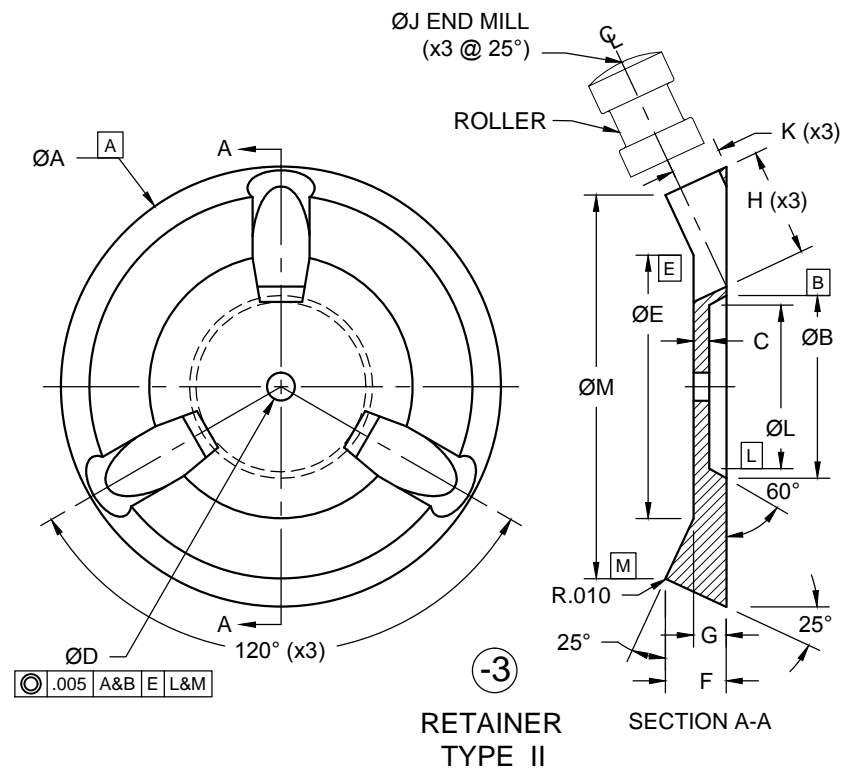
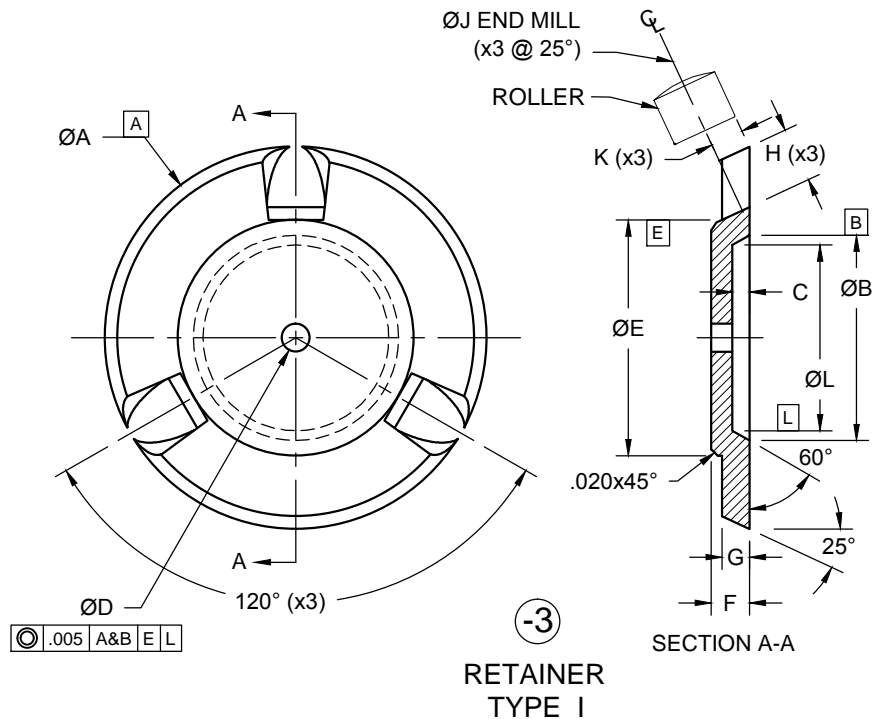
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> RBST1021 THRU 1040 DP SERIES SWAGING TOOL; GUIDE	
<b>DWG NO.</b>	<b>REV</b> 2
<b>TOOL#</b> (see chart)-7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1  FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> PERRITT <hr/> <b>APPROVED</b> <hr/> <b>HEAT TREAT</b> <hr/> <b>FINISH SPEC</b> <hr/> USED ON BEARING <hr/> <b>SEE Pg. 1</b> <hr/> 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
<b>SCALE</b> NTS	<b>DATE</b> 4-26-08
<b>SHEET</b> 5 of 9	

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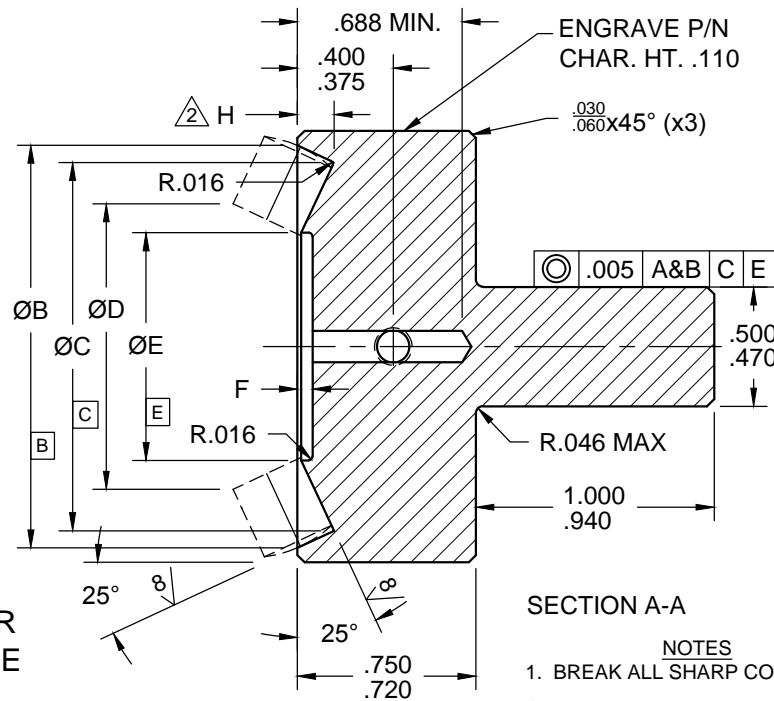
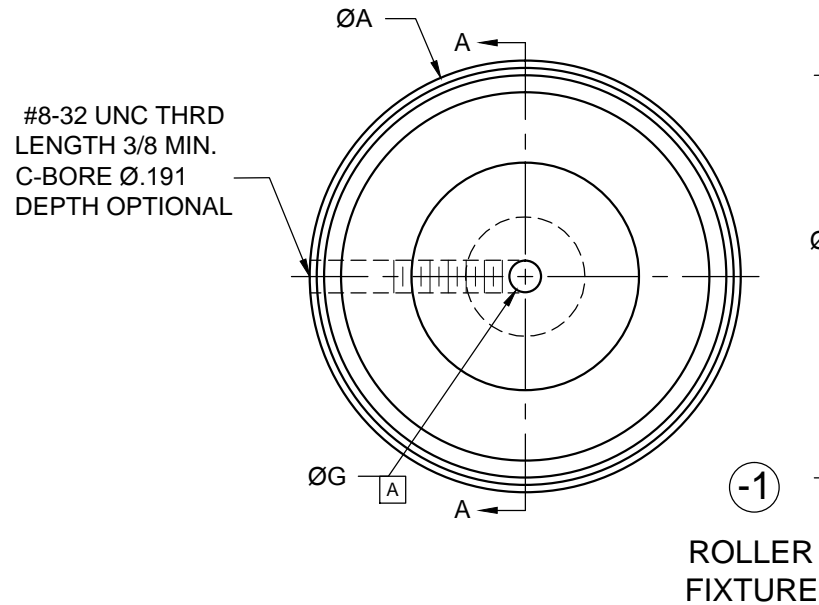
 <b>RED BARN MACHINE</b>	
<b>TITLE</b> RBST1021 THRU 1040 DP SERIES SWAGING TOOL; ROLLER (QTY. 3)	
<b>DWG NO.</b>	<b>REV</b> 2
<b>TOOL#</b> (see chart)-5	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> PERRITT  <b>APPROVED</b>  HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING  <b>SEE Pg. 1</b>
<b>SCALE</b> NTS	<b>DATE</b> 4-26-98 <b>SHEET</b> 4 of 9



- NOTES
- BREAK ALL SHARP CORNERS (.015/.03).


RED BARN MACHINE	
TITLE RBST1021 THRU 1040 DP SERIES SWAGING TOOL; RETAINER	
DWG NO. TOOL# (see chart)-3	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON BEARING SEE Pg. 1	
SCALE NTS	DATE 4-26-08 SHEET 3 of 9

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-1 CH'D TOL.(H) WAS +/- .002 IS +/- .005.	6/17/13	BIM	GE




## SECTION A-A

## NOTES

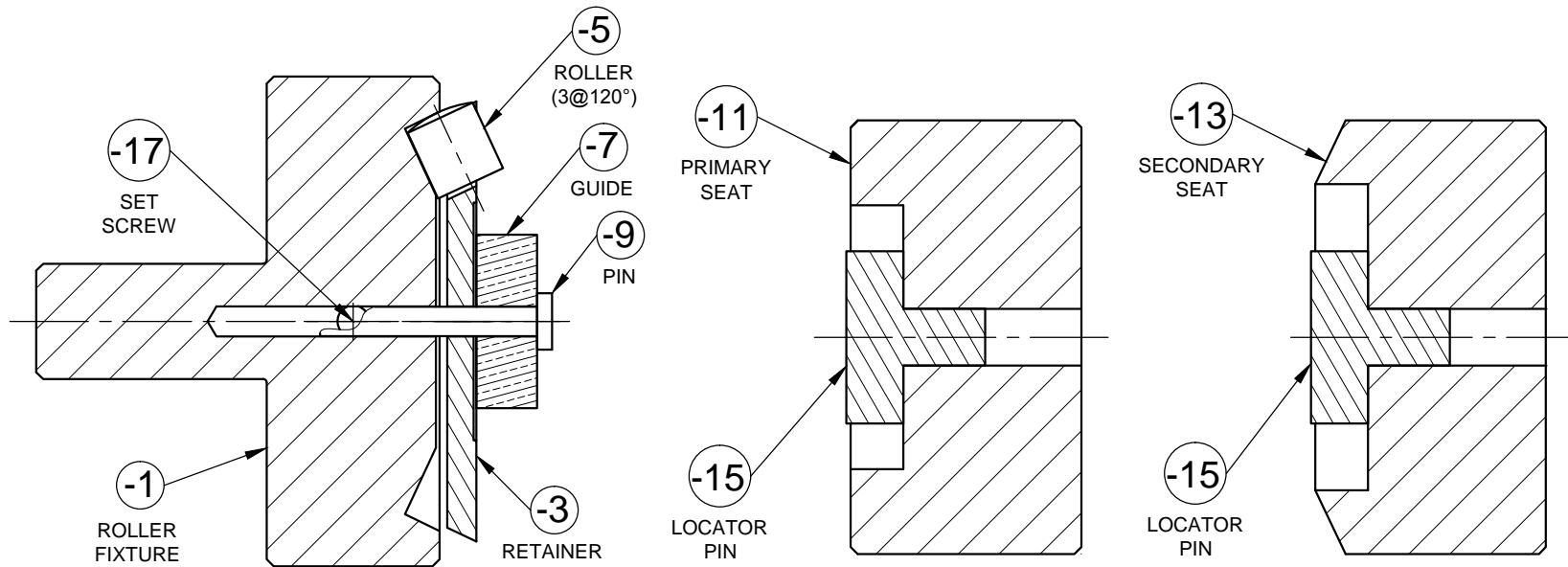
1. BREAK ALL SHARP CORNERS (.015/.03).
2.  DIMENSION TO BOTTOM OF R.016 = H DIM.;  
DIMENSION TO SHARP CORNER= H DIM.+ .005.
3. -1 BEARING RACE SURFACES MUST HAVE  
SMOOTH APPEARANCE, FREE FROM  
MACHINING MARKS AND GROOVES.
4. DO FIRST ARTICLE INSPECTION  
BEFORE HEAT TREATING.

[illegible]

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> RBST1021 THRU 1040 DP SERIES SWAGING TOOL; ROLLER FIXTURE	
<b>DWG NO.</b>	<b>REV</b> 2
<b>TOOL#</b> (see chart)-1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  <b>TOLERANCES ON:</b> DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> PERRITT <b>APPROVED</b> HEAT TREAT RC 55-60 FINISH BLACK OXIDE SPEC USED ON BEARING <b>SEE Pg. 1</b>
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 ± 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
<b>SCALE</b> NTS	<b>DATE</b> 4-26-08
<b>SHEET</b> 2 of 9	



REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED -5 ROLLER RADUIS FROM .005 - .010, TO .015 - .020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
1A	CH'D T/N FROM KST1021 THRU 1040.	11/19/09	RJC	
2	-1 CH'D TOL.(H) WAS +/--.002 IS +/--.005.	6/17/13	BIM	GE



#### NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
206-033-509-3	RBST1034

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8
		-15	1 or 2	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RED BARN MACHINE	
TITLE RBST1021 THRU 1040 DP SERIES TRI-ROLLER SWAGING TOOLS	
DWG NO. TOOL # (SEE CHART ABOVE)	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: PERRITT
TOLERANCES ON:	APPROVED
DECIMALS .XXX ± .005	HEAT TREAT LISTED PER ITEM
FRACTIONS ± 1/32	FINISH LISTED PER ITEM
ANGLES ± .5°	USED ON BEARING
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SEE ABOVE
SCALE NTS	DATE 4-26-08
	SHEET 1 of 9